



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3012
Job Sheet 170448



Part No: 646.3012

Job Qty: 10 ea

Part Name: Lower Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/24/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 1,3,5,8,9 IPP REV:A NEW ISSUE 13/01/30 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/24/18	0.00	0.00	Start Up Machining-1		18-02-17
100	Bandsaw	10 pcs		1/24/18	0.00	0.72	Bandsaw1		11
110	CNC Vertical Machining	10 pcs		1/24/18	0.20	11.49	HAAS1-1		11
120	QC	10 pcs		1/24/18	0.00	0.00	QC2 Machining-1		11
130	QC	10 pcs		1/24/18	0.00	0.00	QC8 Machining-1		18-02-13
131	HandFinish	10 pcs		1/24/18	0.00	0.00	HandFinish2		18-02-14
140	Outsource	10 pcs		1/24/18	0.00	0.00	Outsource4		AT 18/03/01
150	Packaging	10 pcs		1/24/18	0.00	0.00	Packaging2		AT 18/03/01
155	QC	10 pcs		1/24/18	0.00	0.00	QC5		35
180	Packaging	10 pcs		1/24/18	0.00	0.00	Packaging3-1	CE 1013	MAR 02 2018
190	QC21-SA	10 Ea		1/24/18	0.00	0.00	QC2		21 MAR 05 2018

Part Op 100 - Cut Blank at 27.500" ***ONE BLANK MAKE TWO PARTS***

Descriptions: 110 - 1-Machine per folio FB159

131 - CLEAN AND REMOVE ALL PART MARKING

140 - Issue P/O to ATG : 039040

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

FEB 14 2018

10108

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S0.375X8.000	11	25	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								ad hand / Supervisor approval Verification	
								QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Pressure/Fu ☐ Design ☐ Operator ☐ Bending ☐ Doc/Data ☐ Offset/Setup ☐ Centre Not C ☐ Equip/Tooling ☐ Supplier ☐ Cracks ☐ Handling/Pre ☐ Training ☐ Crimp/Kink/Ri ☐ Material ☐ Use for Testing ☐ Cuffs ☐ Internal Transport ☐ Poor Information ☐ Crushing ☐ Tribal Knowledge ☐ Rushing ☐ Heat Treat ☐ LOA ☐ Product Improvement ☐ Wave/Twist in Tu ☐ Substation ☐ Process Improvement ☐ Marks/Chatter ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐ OTHER : _____								ed Wrong Dimensions er tolerance ect lissing	

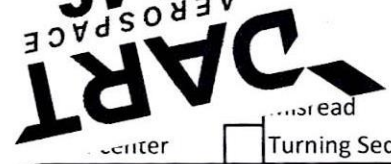
Job No: 170448
Operation 02/07/18

Start up Operation
646.3012

Change No:
Operation:
Revision:
Original Serial #: S039946



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Guide	0.125inches $\pm$ 0.005	0.130 0.120	-1.5	
2	Lower Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	Angle
3	Lower Guide	0.375inches $\pm$ 0.005	0.380 0.370	-377	
4	Lower Guide	0.250inches $\pm$ 0.005	0.255 0.245	Radius	-250
5	Lower Guide	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter	-209
6	Lower Guide	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	-177
7	Lower Guide	0.250inches $\pm$ 0.005	0.255 0.245		-250

Plex 1/16/18 1:25 PM dart.lacelle.linda

DQA: _____ Date: _____

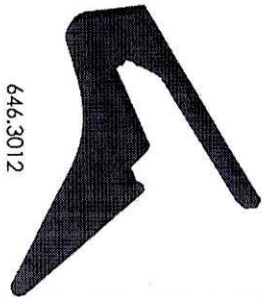
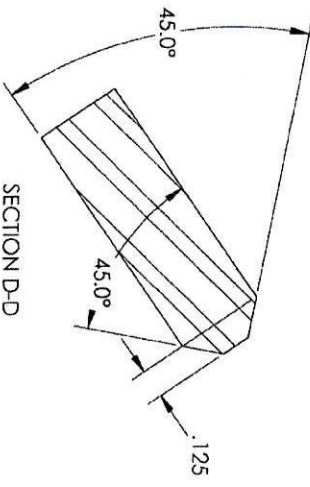
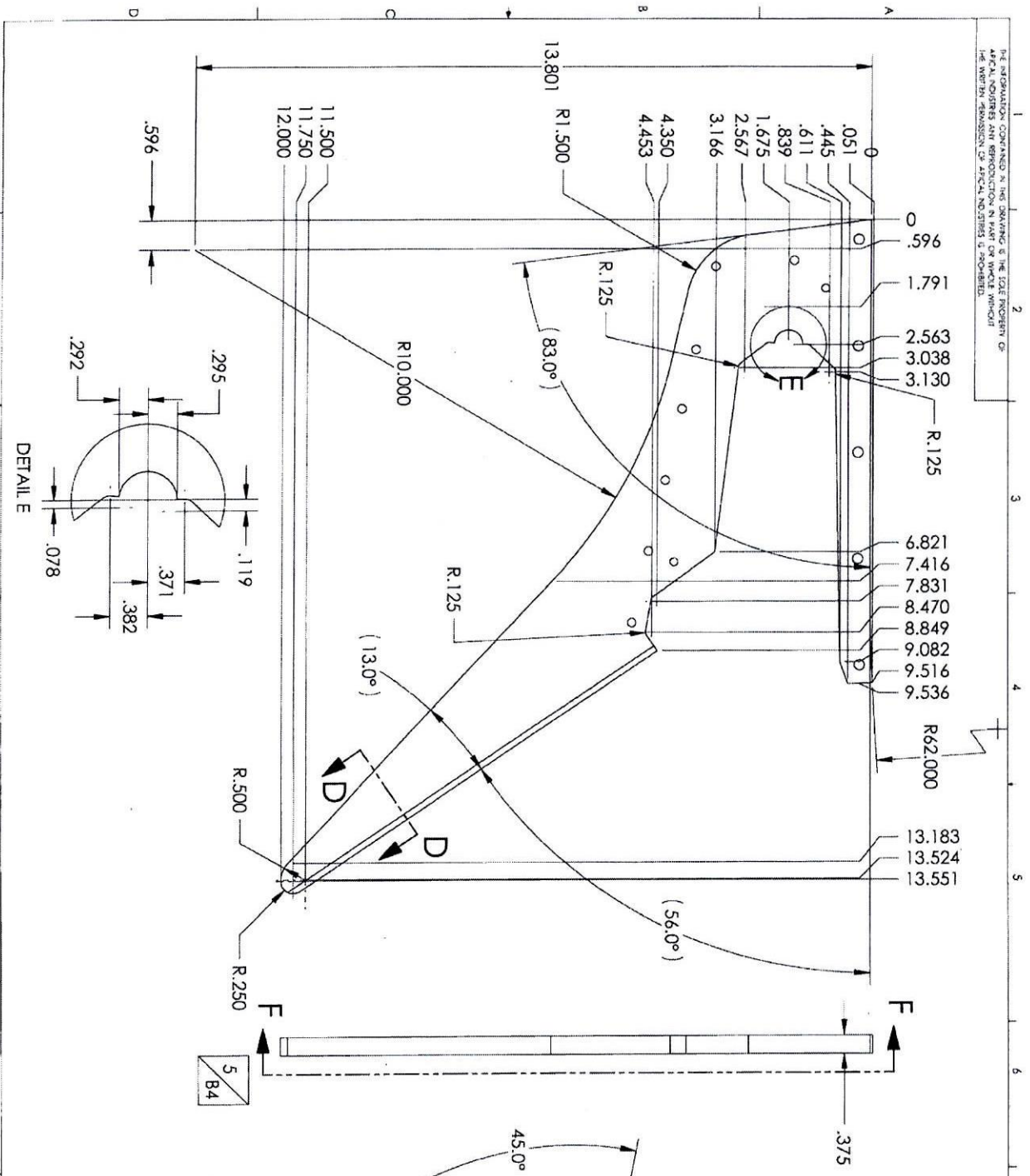
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.



646.3012

REV	DESCRIPTION	DATE	APPROVED

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-5512 (760) 724-5300	
LOWER CUTTER ASSY	
SHEET NO. 646.3000 SCALE: NONE	SHEET 4 OF 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039040

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039040

PO Date: 2/14/18

Due Date: 2/21/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
FEB 22 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171810	649.5111	LH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 1- Black Anodize as per 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	2/21/18	1 pcs	0 pcs	1 pcs	\$17.71/pcs	\$17.71
Line Item Note RUSH!!										
	171811			Firmed	2/21/18	1 pcs	10 pcs	1 pcs	\$17.71/pcs	\$17.71
Sub Total:						2	0	2		\$35.42
2	171809	649.5112	RH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 1- Black Anodize 2- PRIME, SEE NOTE #2 Certification of Conformity is required	Firmed	2/21/18	2 pcs	0 pcs	2 pcs	\$17.71/pcs	\$35.42
Line Item Note RUSH!!!										
3	170448	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	2/21/18	10 pcs	0 pcs	10 pcs	\$21.31/pcs	\$213.10
4	170457	646.3312	Center Plate Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	2/21/18	14 pcs	0 pcs	14 pcs	\$13.46/pcs	\$188.44

DAS
38
9-89
DAS
11
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914686

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577		Fax: 613 632-1655	
Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: 649.5111 LH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22542		Rev: C PO: PO039040 Line: 1
2 ea	Part: 649.5112 RH Wiper Deflector Job: 22543		Rev: C PO: PO039040 Line: 2
10 ea	Part: 646.3012 Lower Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22544		Rev: NC PO: PO039040 Line: 3
14 ea	Part: 646.3312 Center Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22545		Rev: A PO: PO039040 Line: 4
8 ea	Part: 647.3917 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22546		Rev: C PO: PO039040 Line: 5
Made in Canada			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914686

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
6 ea	Part: 649.5213 Doubler Job: 22547	Rev: A PO: PO039040 Line: 6	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>28/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			